**Machining Parameters for CNC Lathe Training**

**Right and Left hand 55° turning tools, 1” diameter stock**:RPM 1200 RPMs

Roughing Depth of Pass 0.050

Feed per Revolution 0.015 per revolution

Finish Cut Depth of Pass 0.010

Finish RPM 1500 RPMs

Finish Feed per Revolution 0.003 per revolution

Note: Use 650 Surface Feet Per Minute(SFM) for Roughing, 800 Surface Feet Per Minute(SFM) for Finishing operations in CNC 2 CAM programs.

**Grooving tool, 1” diameter stock**:

RPM 1000 RPMs

Roughing Feed per Revolution 0.003 per revolution

Finish Cut 0.001

Finish RPM 1000 RPMs

Finish Feed per Revolution 0.003 per revolution

Note: Do NOT use SFM, use RPMs.

**Threading**:

RPM 155 RPMs

Depth of Pass 0.005

Pitch 1/Threads per Inch

Spring Passes 2

Number of Starts 1

Plunge Angle 29.5

Note: Do NOT use SFM, use RPMs.

**Boring**:

RPM 800 RPMs

Roughing Depth of Pass 0.030

Feed per Revolution 0.005 per revolution

Finish Cut Depth of Pass 0.010

Finish RPM 1000 RPMs

Finish Feed per Revolution 0.003 per revolution

Note: Use 400 Surface Feet Per Minute(SFM) for Roughing, 450 Surface Feet Per Minute(SFM) for Finishing operations in CNC 2 CAM programs.